65

Work Order ID 93098

November-14-12 1:44:16 PM

93098

Item ID: D4695-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Channel

Start Date: 14/11/2012 **Start Qty:** 2.00 *2*

Required Date: 05/12/2012 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ML5 **Date:** 12-11-15 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4695	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	**Memo**	0.00				(2)			12-2-16
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
6061.040									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	**Memo**	0.00				(2)			12-2-16
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	**Memo**	0.00				2			
Quality Control									

DAS 15 9-89

12 12 15

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 93098

November-14-12 1:44:16 PM

93098

Item ID: D4695-2 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Channel

Start Date: 14/11/2012 **Start Qty:** 2.00 *2*

Required Date: 05/12/2012 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE	0.00				1			pro SB 13/03/12
	Memo	0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				1			27 13 3 12
	Memo	0.00							
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				1			13-3-12
	Memo	0.00							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [signature] Date: 13/04/01

QA Closed: [signature] Date: 13/3/20

Work Order: 93098

Part No. D4695-2

NCR No. 13-2421

DISPOSITION

Rework	☐
Scrap	☑
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐
Machining	☐	Small Fab	☑	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐
Engineering	☐				
Quality	☐				
Other	☐				

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐	13/03/11	120	1	part on scrap because out of Tolerance QTY (1) RC. improper tooling	DAS 13 QS2042 13/03/18	Scrap destroy noreplace reup to order new Dies to be able to Bend long Parts.	SP 13/03/01 DAS 27	13 3.11	DAS QS2042 13/03/18
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☑									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric to O/S
☐	Cracks
☐	Crushed/Crimped.
☐	Cuffs
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Ripples in Bend
☐	Torque Waves in Extrusion
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damaged
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drill Holes
☐	Drawing
☐	Finish
☐	Folio

☐	Grain
☐	Hardware
☐	Inspection Incomplete
☐	Instructions Incomplete/Unclear
☐	Maintenance
☐	Mislabeled
☐	Misread
☐	Offset
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions

☐	Ovalized
☒	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge

☐	Pressure/Forced
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

RC. tooling

Work Order ID 93098

November-14-12 1:44:16 PM

93098

Item ID: D4695-2
Revision ID:
Item Name: Channel
Start Date: 14/11/2012 **Start Qty:** 2.00 *2*
Required Date: 05/12/2012 **Req'd Qty:** 2.00 *2*
Reference:

Accept *N900040100*

Cust Item ID:
Customer:

Setup Start *NS1*
Stop *NS2*

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC7-Inspect Chemical Conversion Coat	0.00				1			
	Memo	0.00							
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: GA	0.00				1			13/03/12
	Memo	0.00							
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							13/3/12
	Memo	0.00							

DAS 27 28 13 3 12

13-03-12

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
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- ☐ Wave/Twist in Tube

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- ☐ Burrs
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- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

November-14-12 1:44:19 PM

Work Order ID: 93098

93098

Parent Item: D4695-2

D4695-2

Parent Item Name: Channel

Start Date: 14/11/2012 **Required Date:** 05/12/2012

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A 12.08.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	156.6578	1.6	3.368421	4.		
M6061T6S.040									**		IB12-12-16		
6061-T6 .040 Sheet													

Location	Loc Qty	Loc Code
MAT021	156.6578	
121099	156.6578	

123874

(2)

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
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- ☐ Heat Treat
- ☐ Inspection Strip in Tube
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- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

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_____

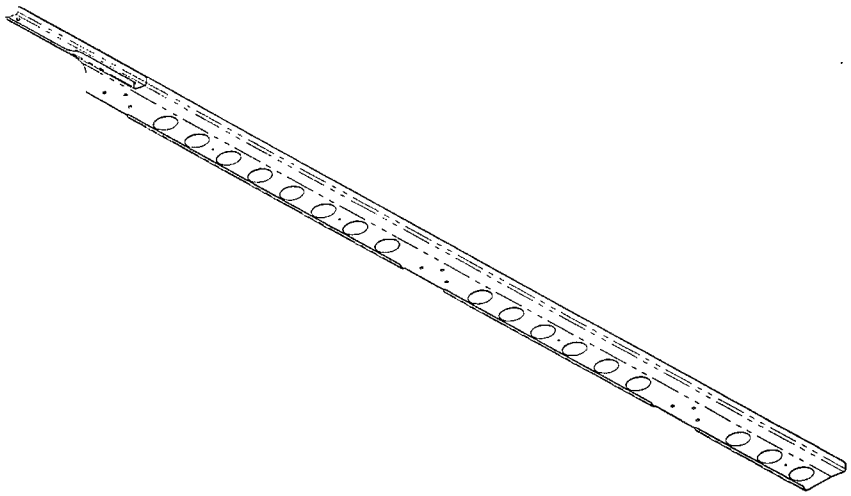
DART AEROSPACE LTD	Work Order:	93698
Description: CHANNEL	Part Number:	D4695-2
Inspection Dwg: D4695-2 Rev: A		Page 1 of 1

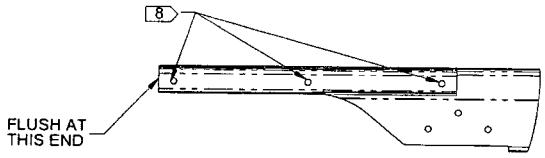
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.25	+.012 -.001	1.251	2		V RO2	
2.20	+/- .030	2.202	2		V	
2.95	+/- .030	2.955	2		V	
3.35	+/- .030	3.353	2		V	
2.76	+/- .030	2.769	2		V	
1.23	+/- .030					
1.37	+/- .030	1.376	2		V	
8.62	+/- .030	8.621	2		PROJ502	
12.02	+/- .030	12.02	2		T RB01	
14.27	+/- .030	14.27	2		T	
12.50	+/- .030	12.50	2		T	
2.50	+/- .030	2.50	2		V	
28.52	+/- .030	28.52	2		T	
31.92	+/- .030	31.92	2		T	
34.17	+/- .030	34.17	2		T	
35.40	+/- .030	35.40	2		T	
53.37	+/- .030	53.37	2		T	
57.02	+/- .030	57.02	2		T	
65.28	+/- .030	65.28	2		T	
.040	+/- .010	.038	2		V	

Measured by: HB for HB	Audited by: DAS 15	Preliminary Approval:
Date: 12-12-16	Date: 12 12 18	Date:

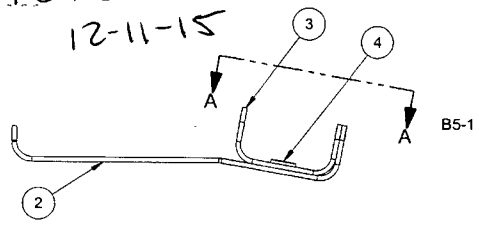
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4695-041	CHANNEL ASSEMBLY
2	1	D4695-1	CHANNEL
3	1	D4695-5	CHANNEL
4	3	MS20426AD4-(3)	RIVET





VIEW A-A C2-1
SCALE 4X

SHOP
RELEASED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 93098 MLJ
12-11-15



RELEASED
2012-11-05

D4695-041 LH CHANNEL ASSEMBLY

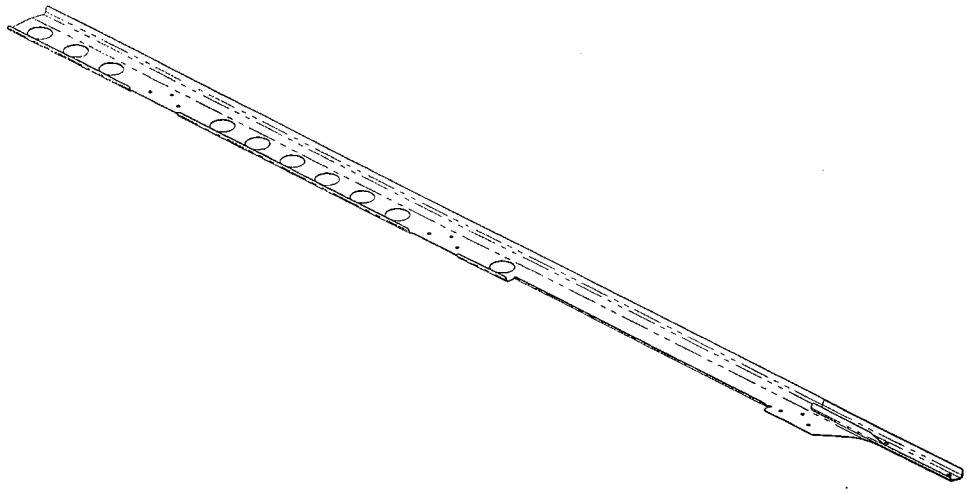
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.75 lbs
8) TRANSFER AND OPEN ∅0.129 FROM D4695-5 TO D4695-1 CHANNEL. CSK D4695-1 CHANNEL ∅ 0.220 x 100°
PRIOR TO INSTALLING RIVETS

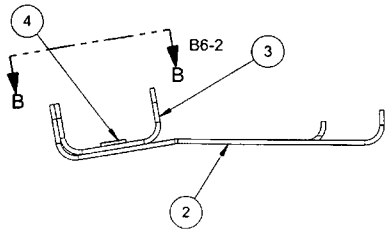
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	12.07.25

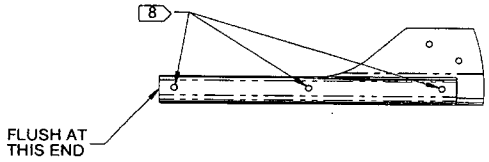
DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	DC	DRAWING NO. D4695 REV. A
MFG. APPR.		SHEET 1 OF 12
APPROVED		TITLE CHANNEL ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.07.25	

93098

ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4695-042	CHANNEL ASSEMBLY
2	1	D4695-2	CHANNEL
3	1	D4695-6	CHANNEL
4	3	MS20426AD4-(3)	RIVET







VIEW B-B C3-2

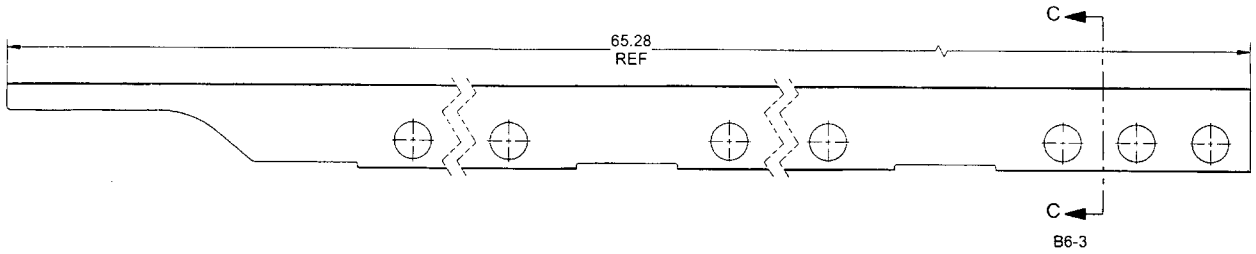
D4695-042 RH CHANNEL ASSEMBLY

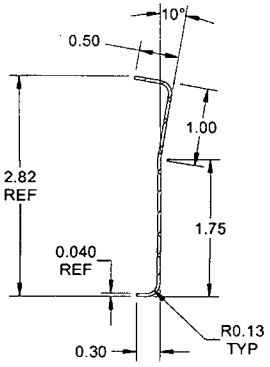
RELEASED
2012 -11- 05

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.74 lbs
8) TRANSFER AND OPEN ∅0.129 FROM D4695-6 TO D4695-2 CHANNEL. CSK D4695-2 CHANNEL ∅ 0.220 x 100° PRIOR TO INSTALLING RIVETS

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4695 REV. A
CHECKED		SHEET 2 OF 12
MFG. APPR.		TITLE CHANNEL ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	12.07.25	

93098





SECTION C-C C3-3

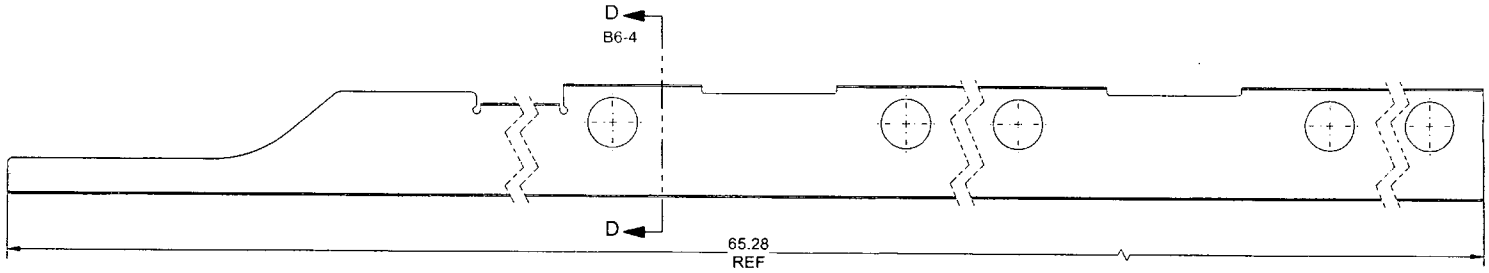
D4695-1 CHANNEL

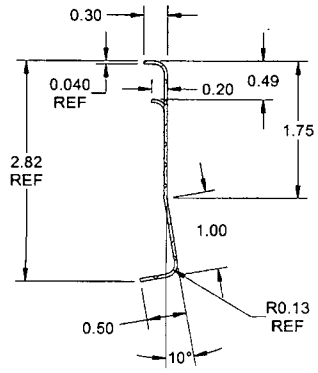
RELEASED
2012 -11- 05

NOTES:
1) MATERIAL: MAKE FROM D4695-1F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JC	DRAWING NO.	REV. A
MFG. APPR.		D4695	SHEET 3 OF 12
APPROVED		TITLE	SCALE
DE APPR.		CHANNEL ASSEMBLY	NTS
DATE	12.07.25		

93098





SECTION D-D D6-4

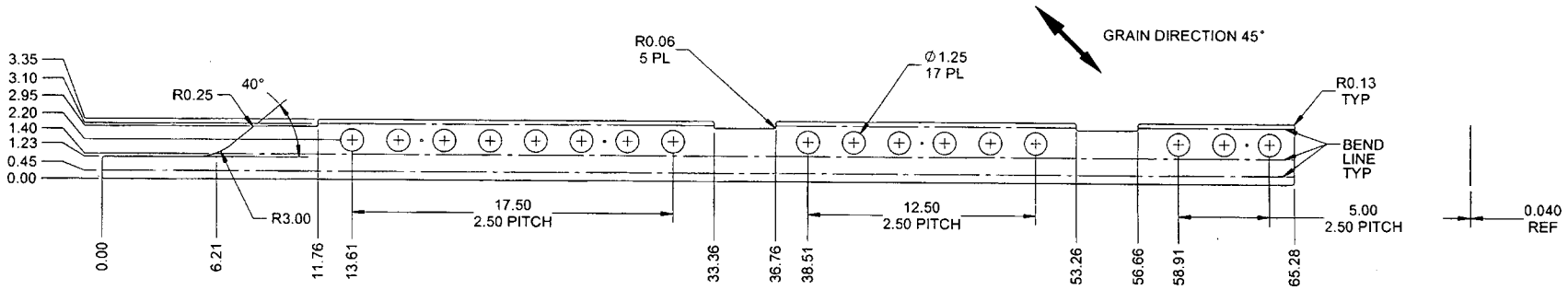
D4695-2 CHANNEL

RELEASED
2012 -11- 05

NOTES:
1) MATERIAL: MAKE FROM D4695-2F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. REV. A
CHECKED	DC	D4695 SHEET 4 OF 12
MFG. APPR.		TITLE SCALE
APPROVED		CHANNEL ASSEMBLY NTS
DE APPR.		
DATE	12.07.25	

93098



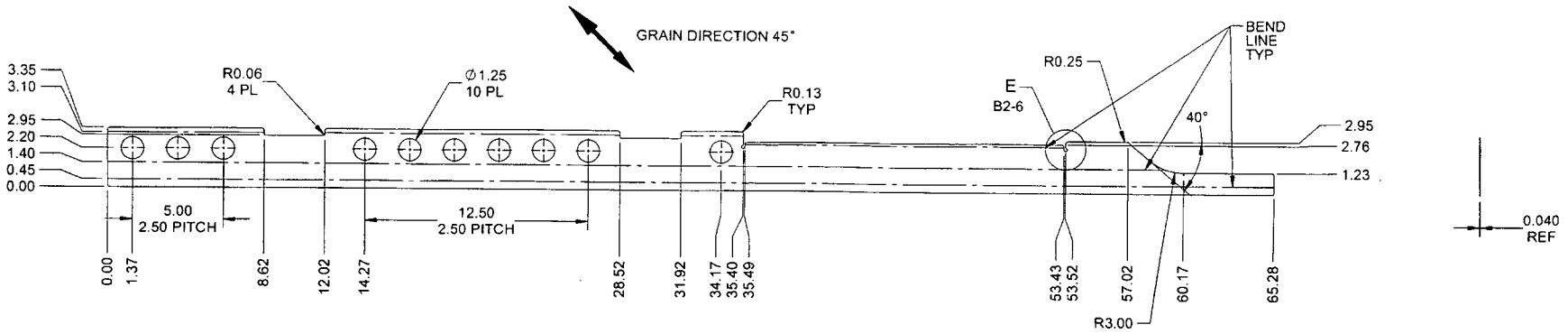
D4695-1F FLAT PATTERN CHANNEL

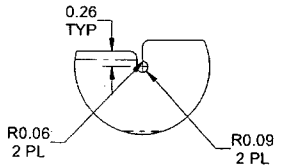
RELEASED
2012-11-05

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	SC	DRAWING NO. D4695 REV. A
MFG. APPR.		SHEET 5 OF 12
APPROVED		TITLE CHANNEL ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.07.25	

93098





VIEW E-E D3-6

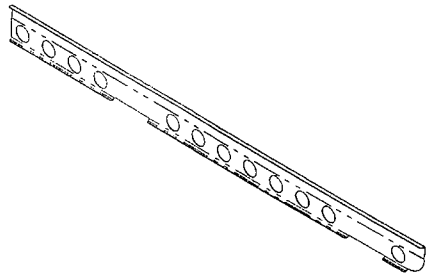
D4695-2F FLAT PATTERN CHANNEL

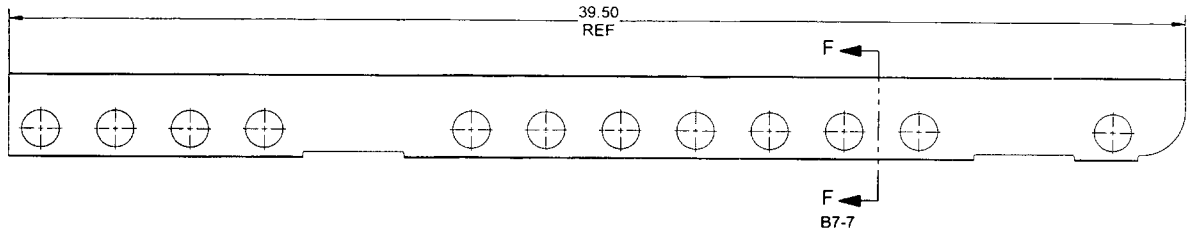
RELEASED
2012 -11- 05

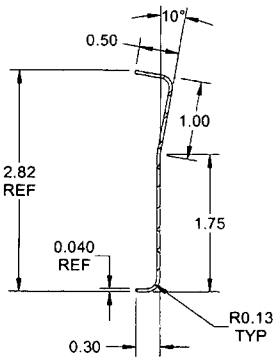
NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.69 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4695 REV. A SHEET 6 OF 12
CHECKED	BC	
MFG. APPR.		TITLE CHANNEL ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	12.07.25	

93098







SECTION F-F C4-7

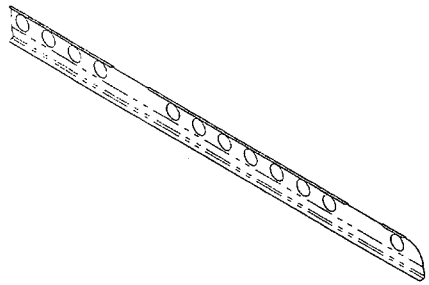
D4695-3 CHANNEL

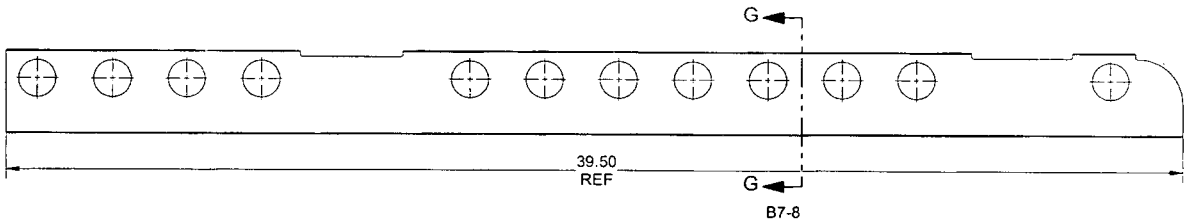
RELEASED
2012 -11- 05

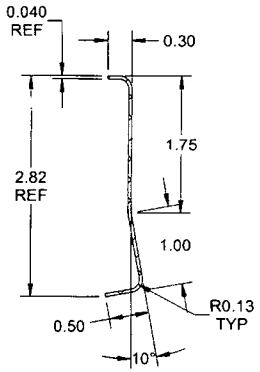
NOTES:
1) MATERIAL: MAKE FROM D4695-3F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.44 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	SC	DRAWING NO. D4695 REV. A
MFG. APPR.		SHEET 7 OF 12
APPROVED		TITLE CHANNEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 12.07.25		

930998







SECTION G-G C5-8

D4695-4 CHANNEL

RELEASED
2012 -11- 05

NOTES:
1) MATERIAL: MAKE FROM D4695-3F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.44 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4695 REV. A
MFG. APPR.		SHEET 8 OF 12
APPROVED		TITLE CHANNEL ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.07.25	

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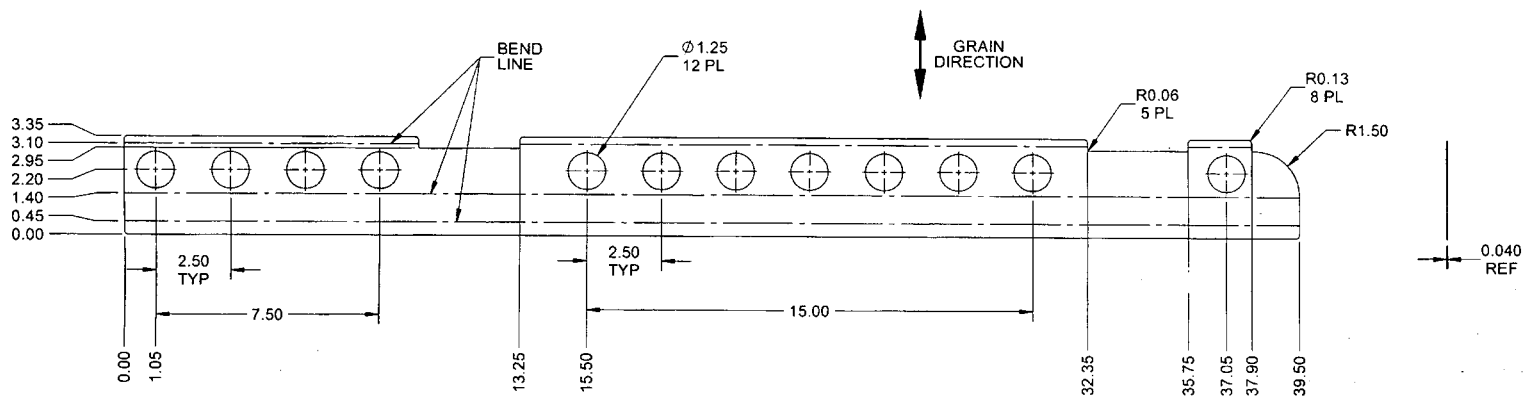

D4695-3F FLAT PATTERN CHANNEL

RELEASED
2012 -11- 05

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.44 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4695 REV. A
MFG. APPR.		SHEET 9 OF 12
APPROVED		TITLE CHANNEL ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.07.25	

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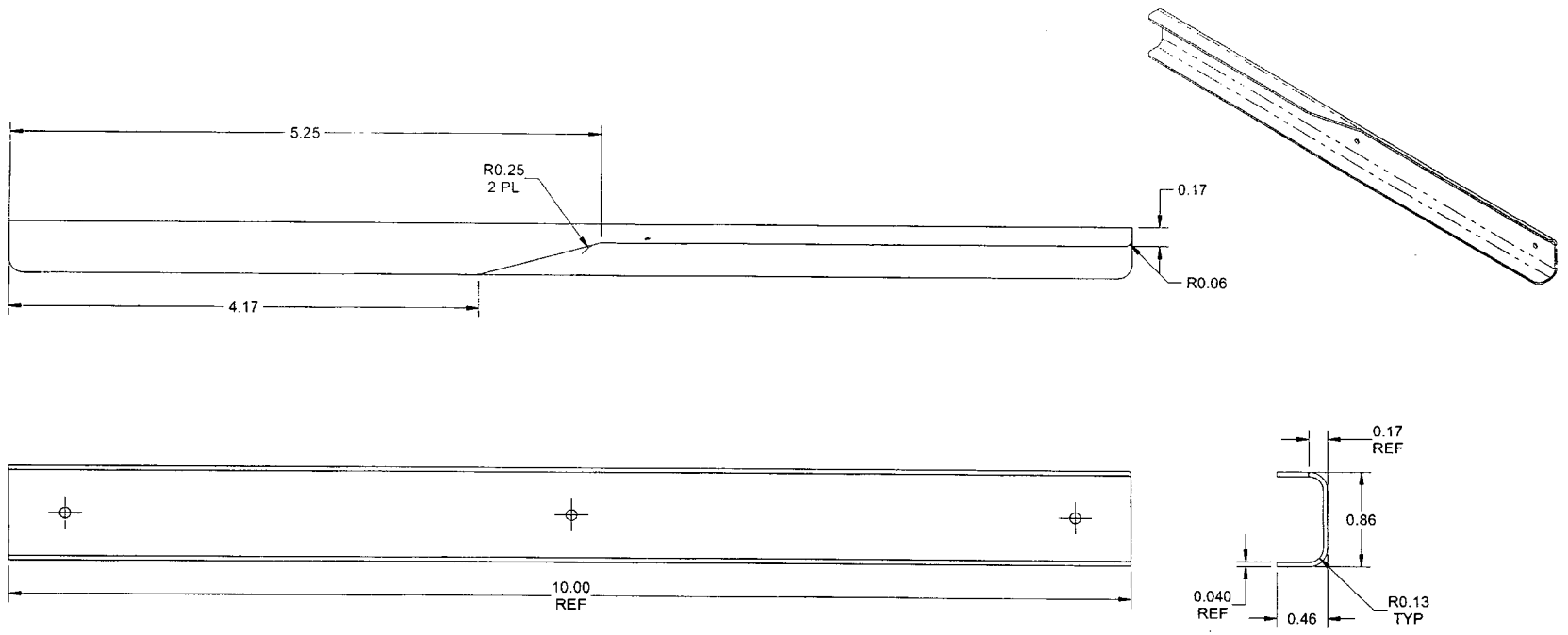


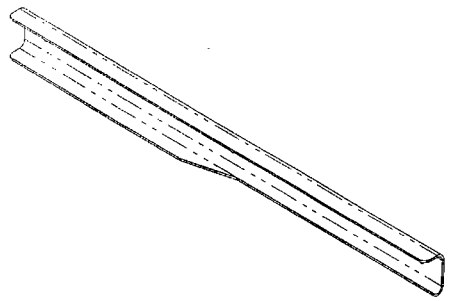
D4695-5 CHANNEL

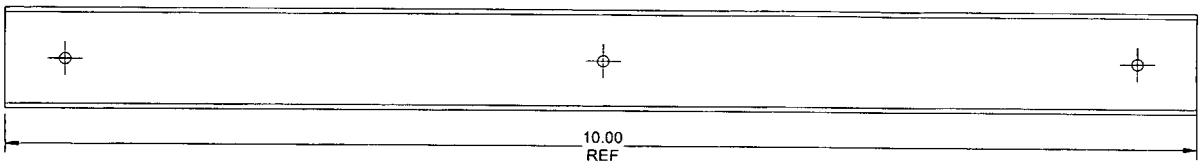
RELEASED
2012-11-05

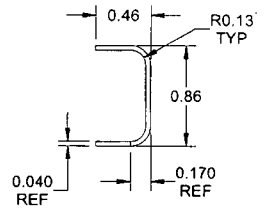
NOTES:
1) MATERIAL: MAKE FROM D4695-5F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.06 lbs

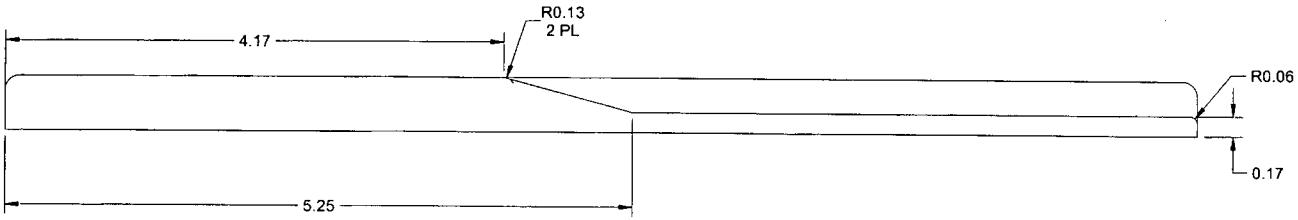
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. REV. A
MFG. APPR.		D4695 SHEET 10 OF 12
APPROVED		TITLE SCALE
DE APPR.		CHANNEL ASSEMBLY NTS
DATE 12.07.25		

93098









D4695-6 CHANNEL

RELEASED
2012 -11- 05

NOTES:
1) MATERIAL: MAKE FROM D4695-5F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.06 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4695 REV. A
MFG. APPR.		SHEET 11 OF 12
APPROVED		TITLE CHANNEL ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.07.25	

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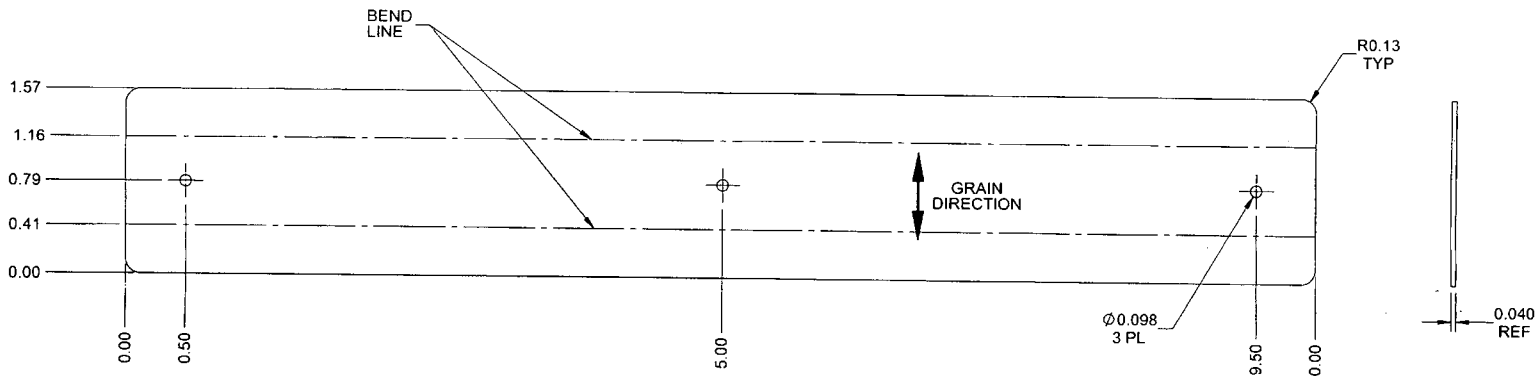

D4695-5F FLAT PATTERN CHANNEL

RELEASED
2012-11-05

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.06 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4695 REV. A
CHECKED	DC	SHEET 12 OF 12
MFG. APPR.		TITLE CHANNEL ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	12.07.25	

avid Duval

om: Roberto Fuentes <rfuentes@dartaero.com>
ent: Tuesday, December 18, 2012 9:58 AM
o: 'David Duval'
c: 'Mike Petsche'; 'Daniel Campbell'; H. Siemens; Kim Johnston
ubject: RE: D4695-1/-2
ttachments: D4695-1F Flat Pattern Channel Rev. A.dxf; D4695-2F Flat Pattern Channel Rev. A.dxf

i David,

ne dimension 1.23" is on the drawing is good, I am send you the new dxf. file and also to Kim too, so she can replace iat is on the network. If the part is already cut, 1.13" at that location is acceptable part for D4695-1/-2. But for next itch please use the new dxf. file. If the D4695-2 is difficult to bend at the section "E" shown in the drawing is ceptable extended the 2.76" dimension in the dxf. file and trimmed after bend to 0.20" as per drawing.

anks of the information.
oberto

om: David Duval [mailto:dduval@dartaero.com]
ent: Monday, December 17, 2012 6:21 AM
o: 'Roberto Fuentes'
c: 'Mike Petsche'; Daniel Campbell
ubject: D4695-1/-2

ne end dimension on the dwg that is 1.23" is not the same on the dxf, it's 1.13". Why? Which one is good?

avid Duval
roduction Engineering Coordinator
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rkesbury Ontario
nada K6A 1K7
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